

Work Order ID 149490

Monday, July 25, 2016 10:52:53 AM

149490

Page 1

Item ID: D2661-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, LH. Fwd, Aft, Out

Start Date: 7/25/2016 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 7/29/2016 Req'd Qty: 2.00 ***2***

Customer:

Reference: touch up, return to stock

REWORK

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2661

Rev E

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Powder Coating

Memo

PULL FROM TRIAL FIT:
2 X D2661-1 B141282

TOUCH UP A/R

0.00

*M/134798.
START: 2:00
OV. T 1 3200.
FINISH: 2:30.*

(X2) ✓

*M. 8/16.08.11
/ff*

2 0 16-11-22 2 3 8

160

QC3- Inspect Part Finish

0.00

160

QC

Quality Control

Memo

0.00

2

*DAS
38
9-89*

NOV 23 2016

170

Identify as per dwg & Stock Location: *81401.*

0.00

170

Packaging

Packaging

Memo

0.00

RE-IDENTIFY USING NEW B/N

2x

NOV 23 2016

*DAS
26
9-89*

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order NCR

Reviewed
DQA:
Date:

Printed on: Thursday, August 18, 2016

Details

Raised Date 8/18/2016	Status Open	Owner Maranda, Denis	Number NCR16-5986
Target Date 9/5/2016	Standard		Severity
Process Inspection		Audit	
Raised By Person Duval, Patrick	Raised Against (Department or Supplier) Engineering	Fault Category General\Finish	

Details

Saddles were use for trial fit by engineering. After trial fit completed saddles had little damage cause by the hardware getting in contact with the saddle and removing the powder coat and in some places the alodine was remove too. In order to fix this issue engineering decided to use white tough paint which turn out to be not acceptable by QC because of the variance in the colour. Parts and work order affected D2666-2 B149493, D2662-1 B149491, D2661-2 B149489, D2661-1 B149490, D2665-2 B149496, D2662-2 B149492, D2665-1 B149495. Picture attach

Keywords	Product D206-642\D2666-1
Document	Root Cause
Closed By	Closed Date
Resolution	

Corrective Action

Target Date 9/5/2016	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions

Number	Owner	Target Date	Completed Date
Details			
1	Smith, Patrick	9/2/2016	
get approval to re powder coat saddles			
2	Sheldon, Andrew	9/2/2016	
after approval from DQA, strip saddles			
3	Roquebrune, Benoit	9/2/2016	
touch up alodine as required and powder coat as per QSI005 4.3			

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Page 2

Item ID: D2661-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Saddle, LH, Fwd, Aft, Out

Stop ***NS2***

Start Date: 7/25/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/29/2016 Req'd Qty: 2.00

2

Customer:

Reference: touch up, return to stock

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

DAS
21
9-89

NOV 24 2016

16/11/24 

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Picklist Print

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Page 1

Work Order ID: 149490

149490

Parent Item: D2661-1

D2661-1

Parent Item Name: Saddle, LH, Fwd, Aft, Out

Start Date: 7/25/2016

Required Date: 7/29/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house
processEC
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD
IPP Rev:D As per Rev D 07-03-19 JLM
IPP REV:D

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2661-1		Manufactured	No				Each	4.0000		2			

D2661-1

Saddle, LH, Fwd, Aft, Out

**

AT 16-08-15

Location

Loc Qty

Loc Code

FG

2

80989

2

ST401

2

141282

2

2

DQA: _____ Date: _____



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Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
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				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : ☐			

Linda Lacelle

From: Steven Drouin
Sent: Thursday, July 21, 2016 2:23 PM
To: Linda Lacelle
Subject: w/o for touch up paint

Hi Linda

I will need a w/o for paint touch up on these parts

D2661-2 x 2 B129615, B121702	149489
D2661-1 x 2 B141282	149490
D2662-1 X 2 B124309	149491
D2662-2 x 2 B129616	149492

D2666-2 x 2 B121591 B113167	149493
D2666-1 x 1 B109550	149494
D2665-1 x 1 B120551	149495
D2665-2 x 2 B136230	149496

And Aft Crosstube
D206-667-201 B140408 149497

Steven Drouin

Dart Aerospace

*Mechanical Designer
Special Projects Coordinator
1270 Aberdeen Street
Hawkesbury, Ontario, K6A 1K7
Email: sdrouin@dartaero.com
Tel: 613-632-5200 ext. 240
Fax: 613-632-9311*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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